

Work Order ID 61500

Friday, August 27, 2010 2:19:23 PM

**PRELIMINARY ISSUE**
Ship Early

Page 1

Item ID: D212-725-1-245

Accept



Setup Start



Revision ID:

Stop



Item Name: Cam

Start Date: 8/30/2010 Start Qty: 2.00



Cust Item ID:



Required Date: 9/3/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *WF*

Date: 10-8-27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D212-725-1

G-PRELIM

100

0.00



Bandsaw

Memo

0.00

*8/10/08/31**2 8*

Jeaspa Bandsaw

Cut blanks 3.250" long

110

0.00



HAAS I

Memo

0.00

*8/10/08/31**2 8*

HAAS CNC vertical machine #1

Machine as per folio FA844 and DWG

Folio rev: *2/1*Dwg Rev: *6*

Deburr as per Dwg

Work Order ID 61500

Friday, August 27, 2010 2:19:23 PM



Page 2

Item ID: D212-725-1-245

Accept



Setup Start



Revision ID:

Stop



Item Name: Cam

Start Date: 8/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/3/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		85 10/28/31		2	1		
130 Mill Conv Conventional Milling Machine	QC2- Inspect parts off machine FAI/FAIB Memo Drill & tap as per Dwg	0.00 0.00		85 10/29/01		2	1		
140 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		85 10/29/01		2	1		

Work Order ID 61500

Friday, August 27, 2010 2:19:23 PM



Page 3

Item ID: D212-725-1-245

Accept



Setup Start



Revision ID:

Stop



Item Name: Cam

Start Date: 8/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/3/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC8- Inspect parts - second check Memo JH-2 JH-03 Uevn.	0.00 0.00				2			
160 HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1 Memo	0.00 0.00				2			
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				2			

Work Order ID 61500

Friday, August 27, 2010 2:19:23 PM

Page 4

Item ID: D212-725-1-245

Accept

Setup Start

Revision ID:

Stop

Item Name: Cam

Start Date: 8/30/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 9/3/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Small Fab

Small Fab

Memo

Insert Helicoil as per Dwg

0.00

⇒ m.l 10/09/01

(2X)

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

Qty 2 good
per Prelim.

1009.01

0.00

0.00

ENGINEERING
APPROVAL

or Q.C. F

200



Packaging

Packaging

Identify as per dwg & Stock Location: _____

Memo

0.00

0.00

10/14/01

SHIPPED TO EAGLE 10/09/02
UNDER POSITIVE RECALL

Work Order ID 61500

Friday, August 27, 2010 2:19:23 PM

Page 5

Item ID: D212-725-1-245

Accept

Setup Start

Revision ID:

Stop

Item Name: Cam

Start Date: 8/30/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 9/3/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

mf
10-9-2

POSITIVE RECALL

EFFECTIVE 10-28-31 AUTH LL

RELEASED _____ DATE _____

Picklist Print

Friday, August 27, 2010 2:19:23 PM

Page 1

Work Order ID: 61500

Parent Item: D212-725-1-245

Parent Item Name: Cam



Start Date: 8/30/2010

Required Date: 9/3/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

627-867		Purchased	No			160	Each	10.0000	2	2			
---------	--	-----------	----	--	--	-----	------	---------	---	---	--	--	--



Heli-coil 10-32

Location

Loc Qty

Loc Code

ST378

10

112748 ✓

10

M6061T6B0.625X02.50		Purchased	No			100	f	9.6130	0.3	0.315789			
---------------------	--	-----------	----	--	--	-----	---	--------	-----	----------	--	--	--



6061-T6 Bar .625 x 2.50

Location

Loc Qty

Loc Code

MAT02

9.613

114351

9.613

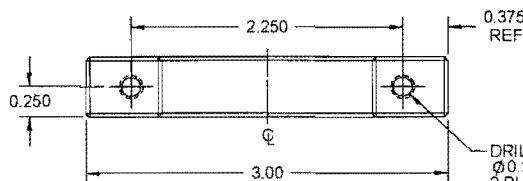
4X M-L 10/09/01

.3158 L-P 10/08/01

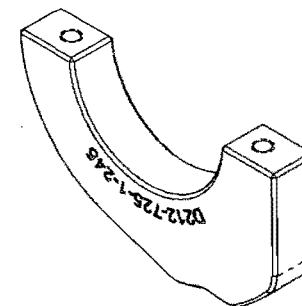
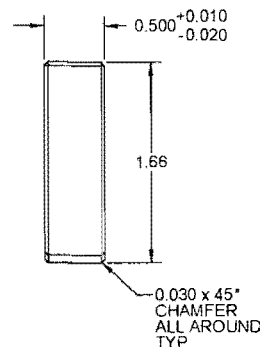
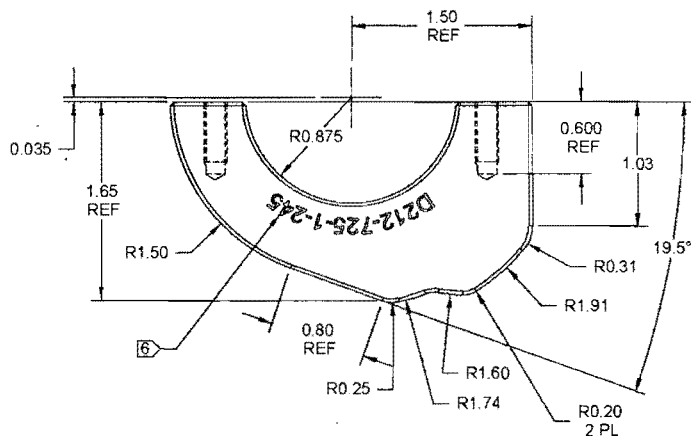
PRELIMINARY ISSUE

ITEM No.	QTY	PART NUMBER	DESCRIPTION
1	1	D212-725-1-245	CAM
2	2	627-867	#10-32 HELICOIL INSERT

w/o 6/500




DRILL AND TAP FOR #10-32 HELICOIL INSERT
 $\varnothing 0.203 \times 0.600$ DP
 2 PL
 INSTALL HELICOIL 627-867 OR EQUIVALENT
 FLUSH WITH SURFACE



D212-725-1-245 CAM

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N IN THIS AREA AS SHOWN TO MAX DEPTH
 OF 0.015 IN 0.135 HIGH LETTERS WITH A MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 0.14 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D212-725-1	SHEET 85 OF 86
APPROVED		TITLE	SCALE
DE APPR.		212S DETAIL PARTS	NTS
DATE	09.09.28	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			